

Work Order ID 69208

Page 1

Wednesday, May 04, 2011 4:16:38 PM

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 5/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

7-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: 115928

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

Pl 11.05.10

110

QC9- Inspect visual per QSI004- Fusion Welds . 0.00



QC

Memo

0.00

Quality Control

BE
Pl 11.05.10

1 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 4/10/11

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

IX ~~Ø~~ M-1 11/05/11

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to

1ST COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

Handwritten signature and date: M. J. 11/05/11

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten signature and date: M. J. 11/05/11

Handwritten number: 116964

Handwritten notes: 1 = 50 OF, 2 = 20 400 OF

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *Q-A*

0.00



Packaging

Memo

u/p 69207

0.00

Packaging

SP 11/05/12 @

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/05/12
*ME**11-05-13*

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, May 04, 2011 4:16:44 PM

Page 1

Work Order ID: 69208

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 5/4/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1 		Manufactured	No			100	Each	14.0000	1	1			
Rib													

Location	Loc Qty	Loc Code
WA006	14	
67350	2	
67465	12	

D2221-5 		Manufactured	No			100	Each	6.0000	2	2			
Rib													

Location	Loc Qty	Loc Code
WA006	6	
67399	6	

D2221-7 		Manufactured	No			100	Each	5.0000	1	1			
Rib													

Location	Loc Qty	Loc Code
WA006	5	
65854	1	
67274	4	

D2232-3 		Manufactured	No			100	Each	0.0000	2	2			
Basket Hinge													

Location	Loc Qty	Loc Code
WA006	2	

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Page 2
3

Work Order ID: 69208

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/4/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2235-1

Basket Rib

Manufactured No

100 Each

18.0000

2 2



Pl 11.05.10

Location

Loc Qty

Loc Code

WA

10

68606

10

WA005


8

66895

8

1 2

2

D2581

Mounting Bracket

Manufactured No

100 Each

4.0000

2



Pl 11.05.10

Location

Loc Qty

Loc Code

WA005

4

66806

4

2

2

D3442-1

Shim

Manufactured No

100 Each

13.0000

2



Pl 11.05.10

Location

Loc Qty

Loc Code

WA005

13

64271


2

65783

11

2

2

D3825-041

Rib Assembly (Basket End)

Manufactured No

100 Each

2.0000

2



Pl 11.05.10

Location

Loc Qty

Loc Code

WA

2

67476

2

2

2

D3826-041

Rib / Gusset Assembly

Manufactured No

100 Each

0.0000

2



366893 -> Pl 11.05.10

Wednesday, May 04, 2011 4:16:45 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Pieclist Print

Wednesday, May 04, 2011 4:16:45 PM

Page 3

Work Order ID: 69208

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 5/4/2011

Required Date: 5/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3827-041

Manufactured No

100 Each

5.0000

1



Rib Assembly (Inboard)



Pl 11.05.10

Location

Loc Qty

Loc Code

WA006

5

67275

5

D3832-1

Manufactured No

100 Each

3.0000

1



Mesh (Base)



Pl 11.05.10

Location

Loc Qty

Loc Code

WA

3

67477

3

D3833-1

Manufactured No

100 Each

15.0000

2



Mesh (Base End Face)



Pl 11.05.10

Location

Loc Qty

Loc Code

WA

15

65937

6

67459

9

Pl 11.05.10

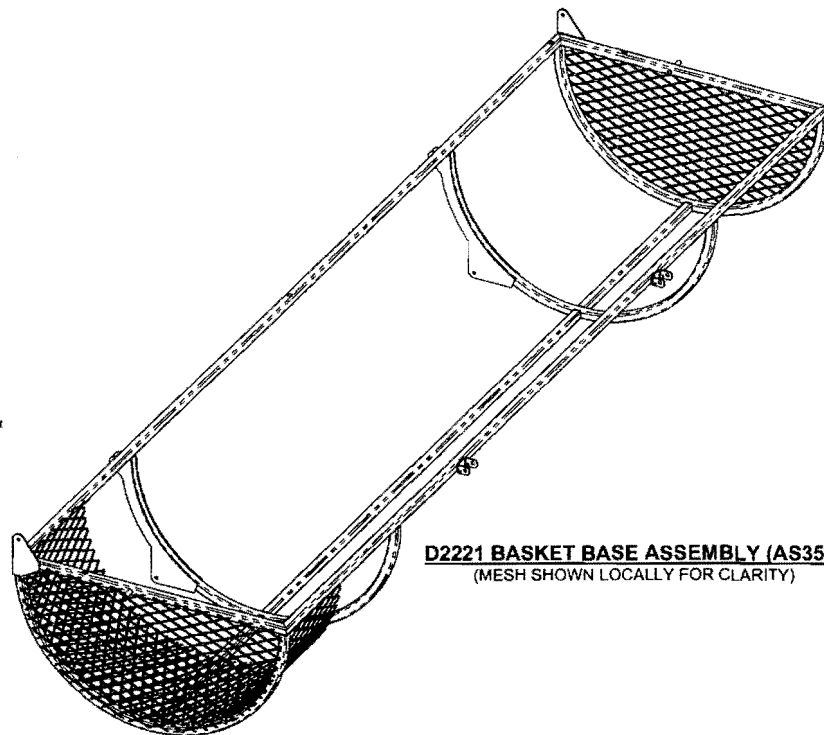
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69208

11/05-4

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 42.00 lbs APPROX
 - 8) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

REVISED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D6-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +10.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.05.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

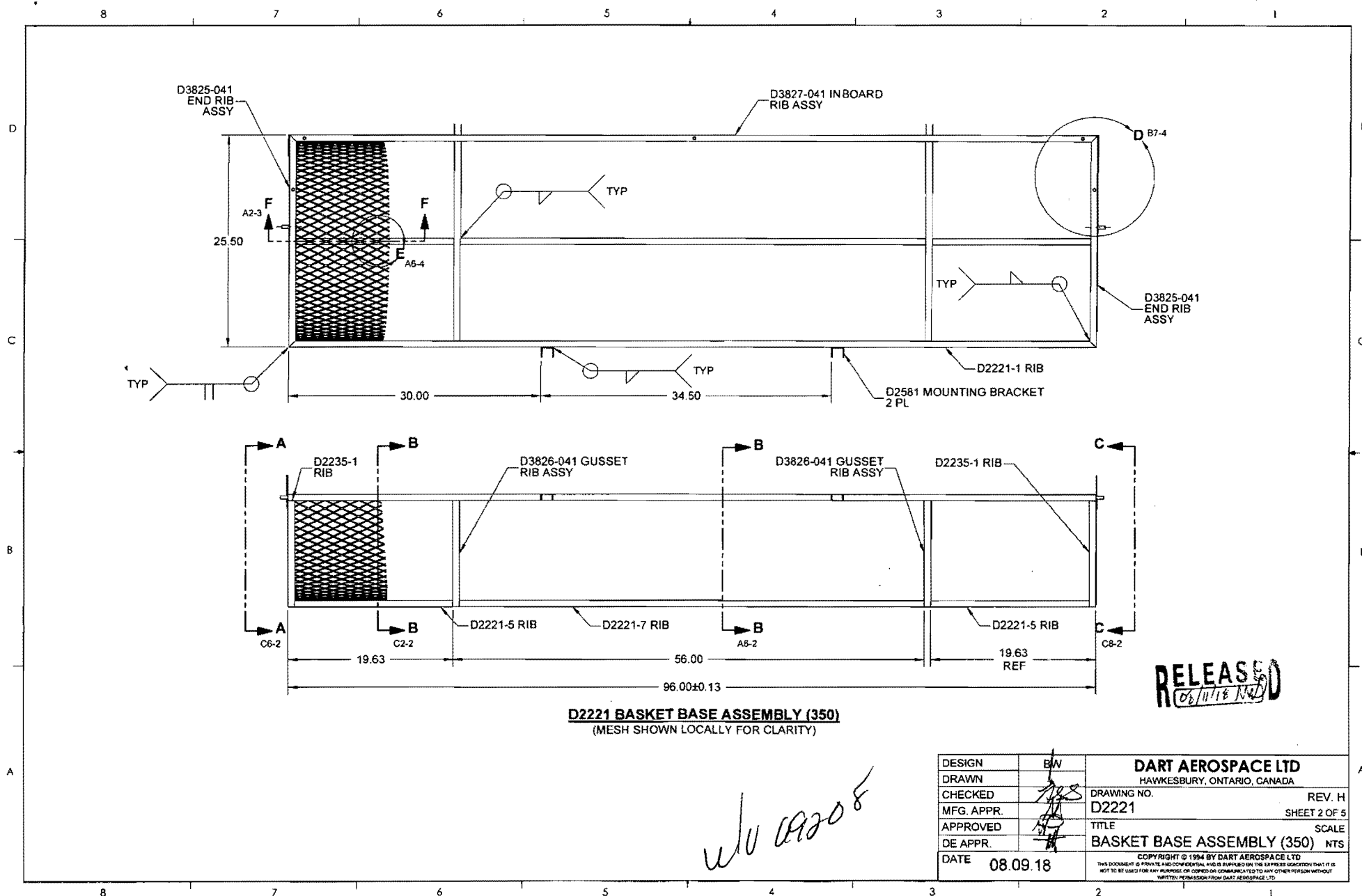
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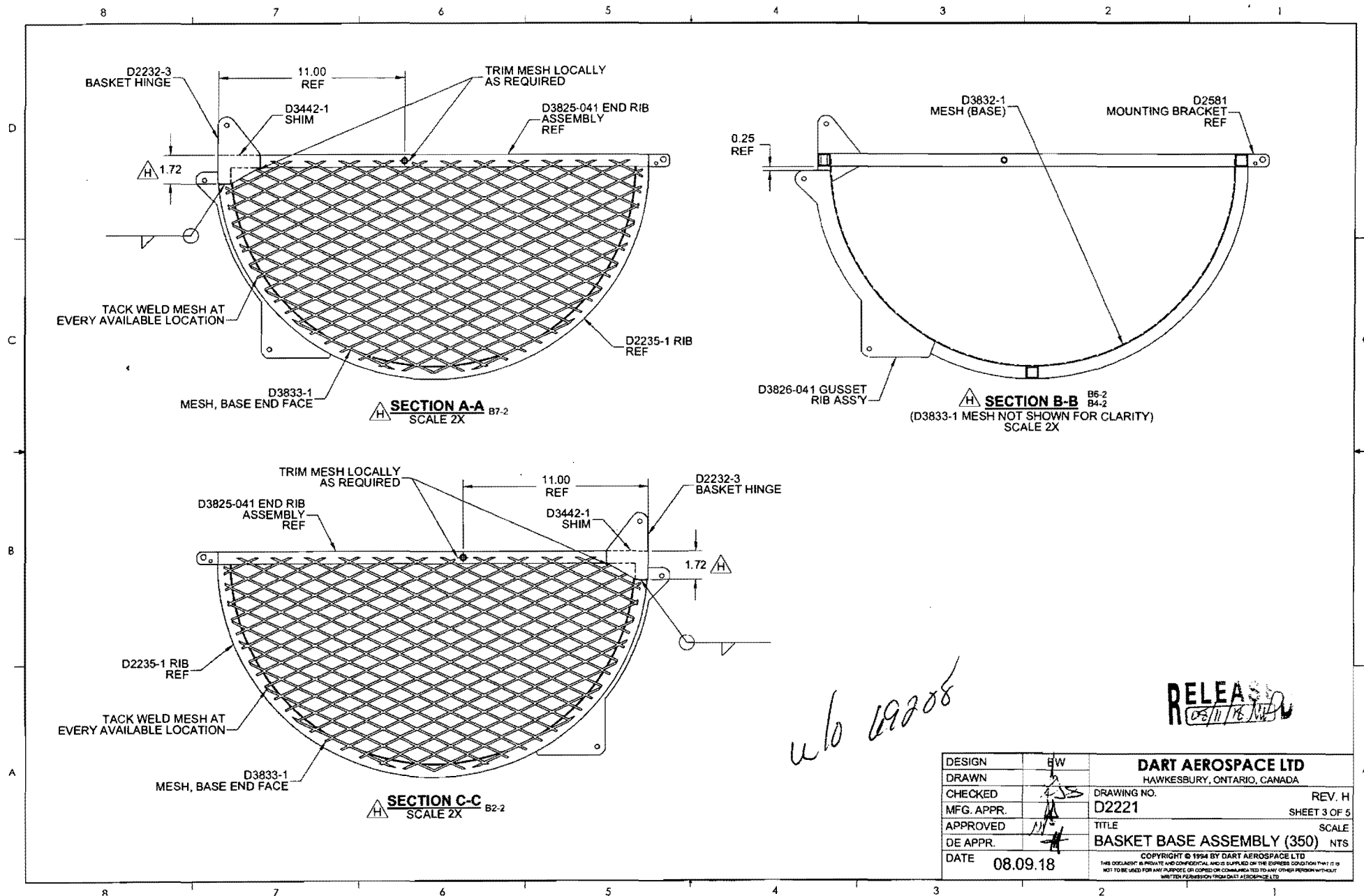
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8

7

6

5

4

3

2

1

D

D

C

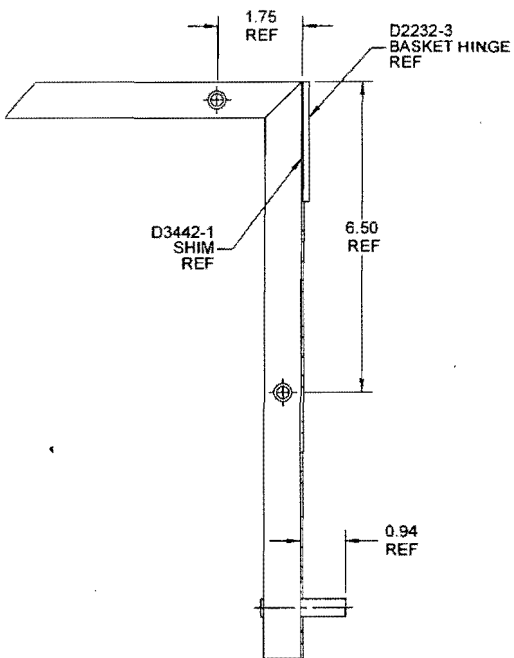
C

B

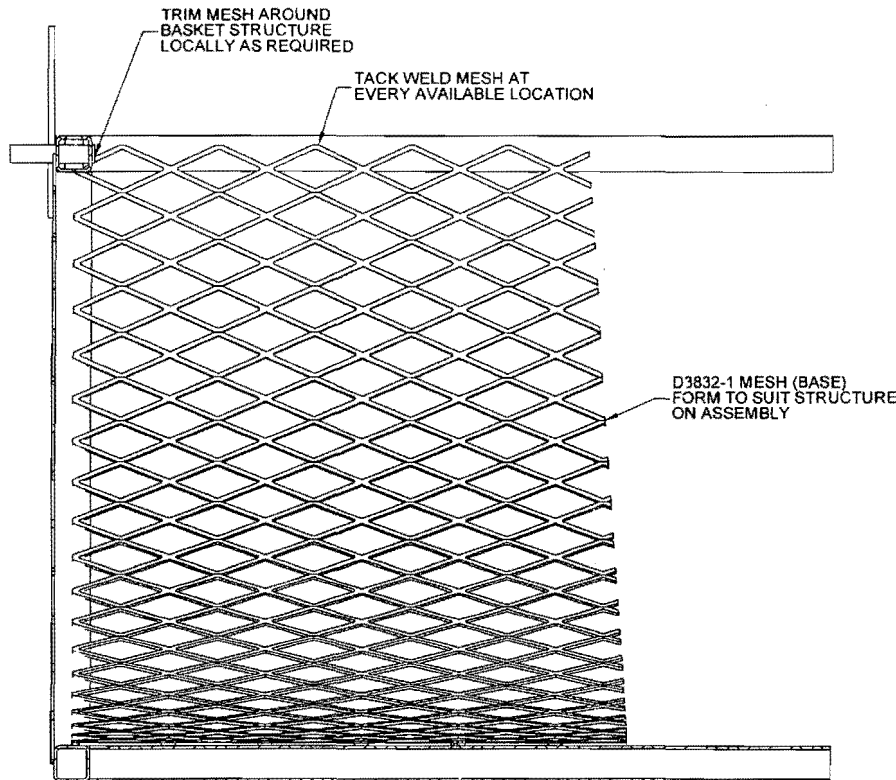
B

A

A

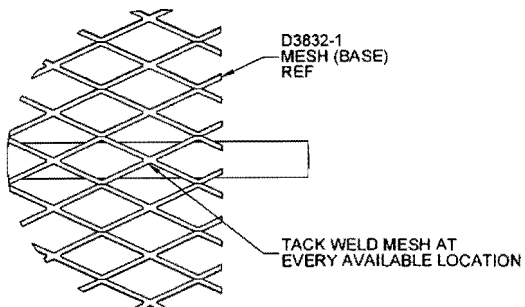


DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2

RELEASED
02/11/8 NIP



DETAIL E
SCALE 4X C6-2

w/o 19208

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2221	REV. H
MFG. APPR.	<i>[Signature]</i>	TITLE	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 1984 BY DART AEROSPACE LTD	
DATE	08.09.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

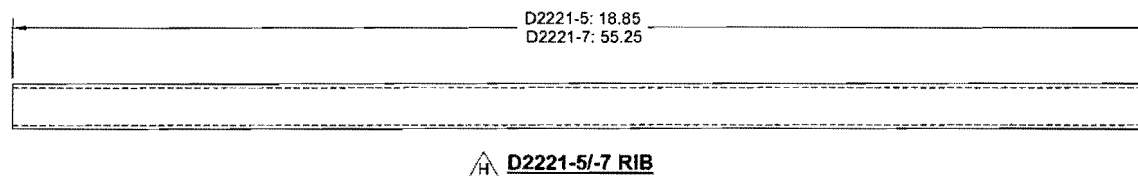
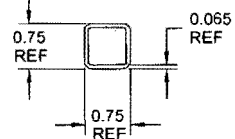
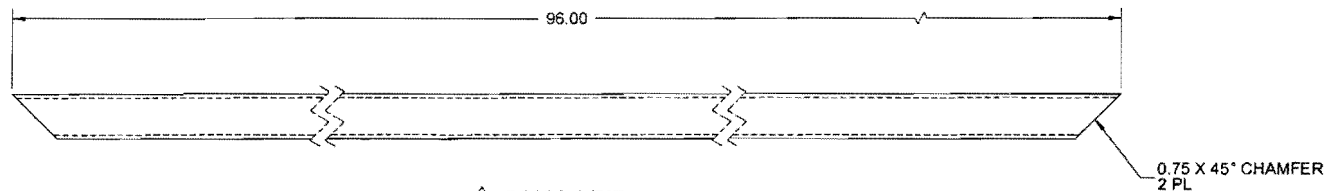
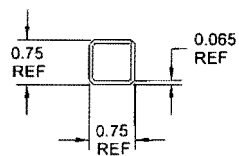
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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RELEASED
08/11/18

w/o 69208

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